Dart Aerospace Ltd.

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 36107		
Estimate Number	: 10274		
P.O. Number	:	**Part Number**	: D350591312
This Issue	: 12/5/2007 **S.O. No.** :	**Drawing Number**	: D3272 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: B
Previous Run	: 36106	**Material**	:
Written By	:	**Due Date**	: 1/2/2008 **Qty:** 10 **Um:** Each
Checked & Approved By	: 07.12.05		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and type labels as per PPP D350-591-312 CHG001 08.10.25

2.0	D32721	STEP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
STEP
BATCH: 35805 07.12.20 10

3.0	D30671	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3067-1	End Plate	B35804

07.12.20 10

4.0	D32191	Support

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3219-1	Support	B36114

07.12.20 10

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 36107

Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY 07-12-20 10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 07-12-20 10

A/R Aluminum Rod M105058 M105844

3-Grind End Plate flush A.M 08.01.02 10

Seq. #:	Machine Or Operation:	Description :
6.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 08/01/02 (10)

Seq. #:	Machine Or Operation:	Description :
7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 08/01/02 (X10 RH)

Seq. #:	Machine Or Operation:	Description :
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 A.M 08.01.02 (10)

Seq. #:	Machine Or Operation:	Description :
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-01-16 10

Seq. #:	Machine Or Operation:	Description :
10.0	D3065041	Step Leg Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3065-041	Step Leg Assy	~~B36410=4~~ ~~B35692=16~~ B35622=10

08.01.16 10

Seq. #:	Machine Or Operation:	Description :
11.0	D30661	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3066-1	Spacer	B36410=4 B35692=16

08-01-16 10

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 36107
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0 -	MS20600AD4W4	Rivets

Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)
Pick:
Qty Part Number Description Batch
16 MS20600AD4W4 Rivet 3106302
08.01.16 10

13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Assemble Leg Assembly as per Dwg D3272.
08.01.16 10

14.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
08/01/17 x10RH

15.0	D30671	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3067-1 End Plate 335804
08.01.16 10

16.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024 — 08.01.16 10

3-Weld Aft End Plate as per QSI 004 & Dwg D3272 — 08.01.16 10
A/R Aluminum Rod M1C5058 — 08.01.17 10

4-Grind End Plate flush SAD 08:01:17 (10)

5-Install last rivet. — 08.01.17 10

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 36107
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
17.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 08-01-17 (10)
18.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/01/18 x10 RH
19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Touch up Alodine	SAD 08/01/20 (10)
20.0	POWDER COATING	POWDER COATING
	M 106379	(10)
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3.	BK 08-01-21
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	M106339	
	Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3272 and QSI 005 4.4	FL 08/01/21 (10)
22.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		08-01-23 (10)
	Comment: Inspect Powder Coat and Wing Walk	
23.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
24.0	D22303	Mounting Lug
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 4 D2230-3 Mounting Lug 335800	8/1/23 SP (10x)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 36107
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	D2618	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2618 Bushing B35096 SP

Seq. #:	Machine Or Operation:	Description :
26.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2856-400-720 Abrasion Strip B35900 SP

Seq. #:	Machine Or Operation:	Description :
27.0	D32351	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D3235-1 Mounting Lug B33249 33249 SP

Seq. #:	Machine Or Operation:	Description :
28.0	D3278041	Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D3278-041 Support Assembly B36119 SP

Seq. #:	Machine Or Operation:	Description :
29.0	AN335A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN3-35A Bolt M105408 SP

Seq. #:	Machine Or Operation:	Description :
30.0	AN413A	Bolt

PTO PTO

Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M106513 8/1/23 SP OX

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ PAR #: ______ Fault Category: ________ NCR: Yes (No) DQA: [signature] Date: 08/01/23

QA: N/C Closed: _____ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
08-01-23	30.0	1 bolt was found defective during kit inspection. Bolt is too short, it has no threads.	[signature] 08/01/24	- Scrap 1x AN4-13A m 106513. - replace Qty 1 AN4-13A m 106513	[signature] 8/01/24	[signature] 08-01-24	[signature] 08/01/2	[signature] 08-01-23

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 36107 | **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	AN536A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN5-36A Bolt M106513 SO

Seq. #:	Machine Or Operation:	Description :
32.0	AN960JD10	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD10 Washer M106167 SO

Seq. #:	Machine Or Operation:	Description :
33.0	AN960JD416	Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 AN960JD416 Washer M106277 SO

Seq. #:	Machine Or Operation:	Description :
34.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M106167 SO

Seq. #:	Machine Or Operation:	Description :
35.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) 105558 8/1/23 SO (10x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	LONG STEP ASSEMBLY HIGH SKID RH
Job Number:	36107	Part Number:	D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
36.0	MS21042L4	Nut

P70 P70

Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) M105938

SD

Seq. #:	Machine Or Operation:	Description :
37.0	MS21042L5	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L5 Nut (or -5) M105940 8/1/23 SD (10x)

Seq. #:	Machine Or Operation:	Description :
38.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 08/01/25 (+10)

Seq. #:	Machine Or Operation:	Description :
39.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-591-312
Location: Rev B AS 08/01/25 (10)

Seq. #:	Machine Or Operation:	Description :
40.0	QC21	FINAL INSPECTION/W/O RELEASE

(10)

Comment: FINAL INSPECTION/W/O RELEASE 08/01/29

Job Completion

2008/1/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-312 PAR #: N/A Fault Category: Prod / Packaging NCR: (Yes) No DQA: [signature] Date: 08/01/29

QA: N/C Closed: [signature] Date: 08.01.29

NCR: 36107		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
08-01-23	36.0	1 kit missing qty 4 of MS21042L4 nut	[signature] 081012	Add missing 4 nuts to kit m 105938	[signature] 8/01/24	[signature] 08-01-24	[signature] 081012	[signature] 08-01-23

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3272 REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS

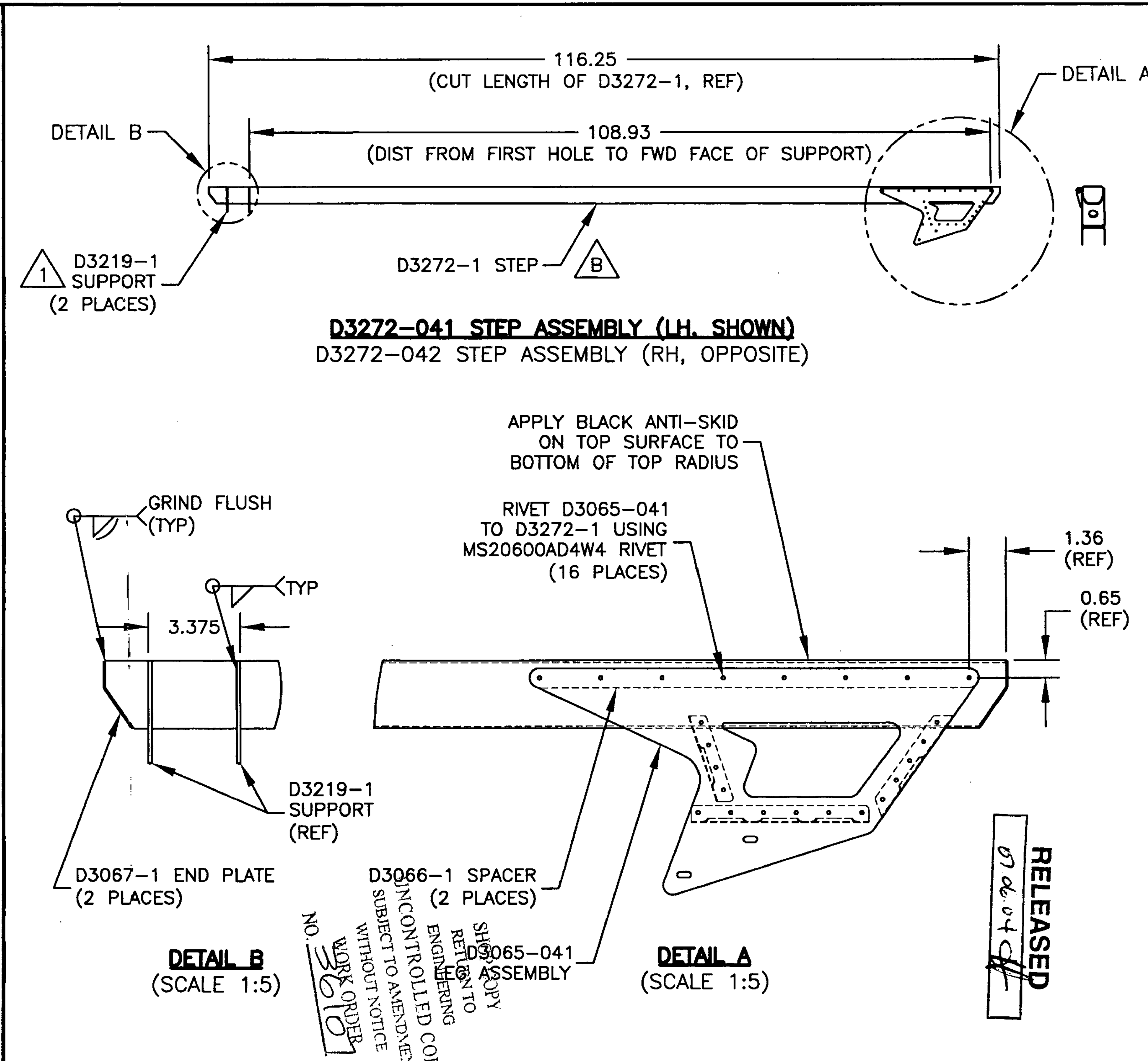
A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1 (B)	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.



DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY
CHECKED	APPROVED

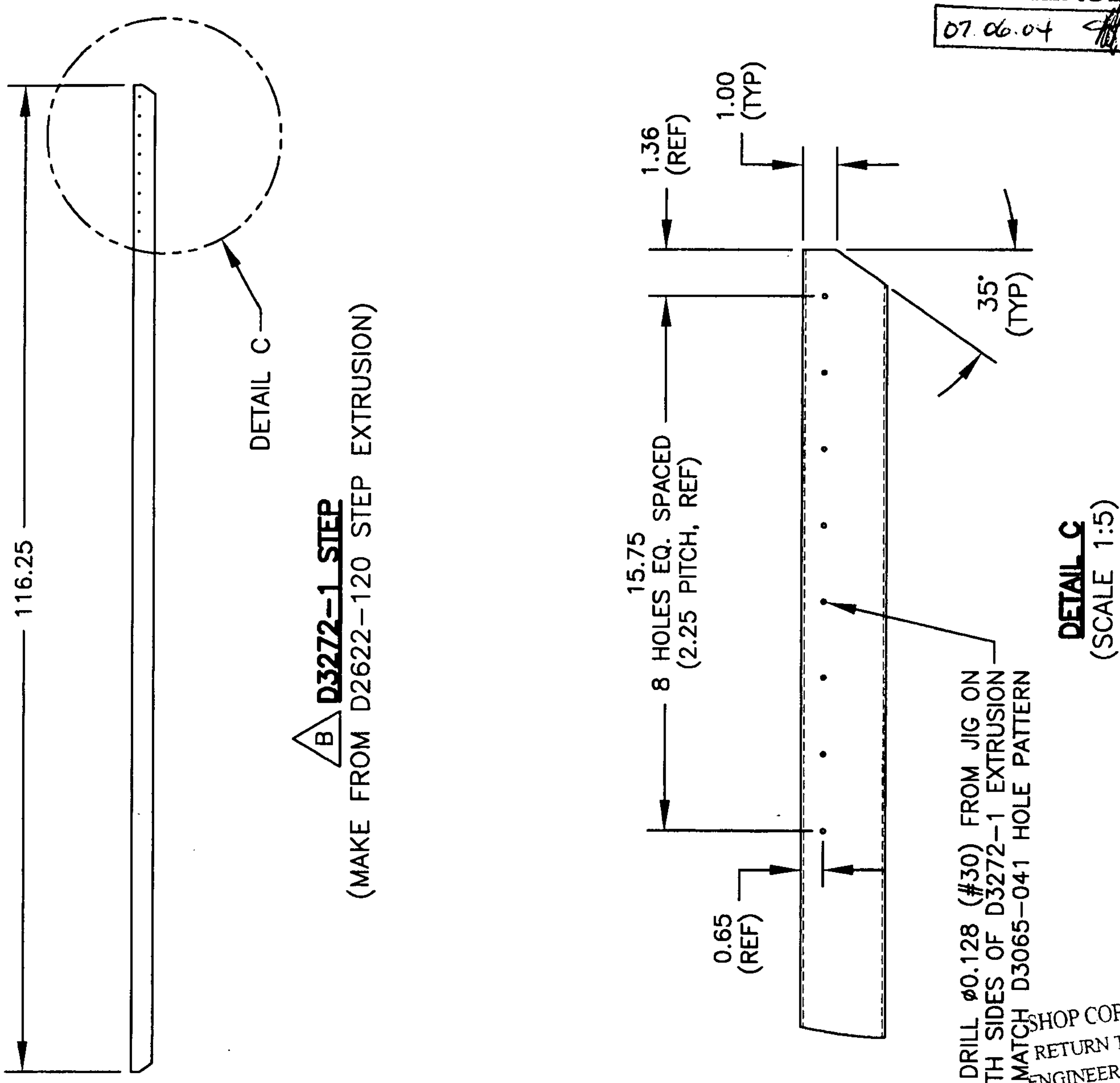
DRAWING NO. D3272 — REV. B — SHEET 2 OF 3

TITLE: STEP ASSEMBLY, HI LONG

DATE: 07.05.18 — SCALE: 1:20

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED 07.06.04



Date: Wednesday, 12/5/2007 8:01:27 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 36107		
Estimate Number	: 10274		
P.O. Number	:	Part Number	: D350591312
This Issue	: 12/5/2007 S.O. No. :	Drawing Number	: D3272 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 36106	Material	:
Written By	:	Due Date	: 1/2/2008 Qty: 10 Um: Each
Checked & Approved By	: 07.12.05		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM		

Additional Product

Job Number:

Seq. #	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and type labels as per PPP D350-591-312 CHG001 07.12.12

Seq. #	Machine Or Operation:	Description :
2.0	D32721	STEP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
STEP
BATCH:____________

Seq. #	Machine Or Operation:	Description :
3.0	D30671	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3067-1	End Plate	________

Seq. #	Machine Or Operation:	Description :
4.0	D32191	Support

REFERENCE ONLY

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3219-1	Support	________